

Work Order ID 70040

Wednesday, May 25, 2011 1:03:49 PM



Page 1

Item ID: D3371-1

Accept



Setup Start



Revision ID:

Item Name: Pedal Lock Base

Stop



Start Date: 5/25/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 6/10/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan:

CL

Date: 11/05/25

Tooling: _____ Date: _____

Run Start



QC:

Date: _____

SPC (Y/N):

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr	Revision Nbr
D3371	Rev B

100



BAND SAW

0.00

CL 11/05/30

4 8

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blank: 2.00" x 2.25" x 7.370" long

110



HAAS CNC VERTICAL MACHINING #1

0.00

B.A 11/05/30

4 φ

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Machine D3371-1 as per Folio FA486 and Dwg D3371 □ Deburr □ Finish 8-32
thread by hand □ Identify as D3371-1

120



QC2- Inspect parts off machine FAI/FAIB

0.00

B.A 11/05/31

4 φ

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run

Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

I30

QC8- Inspect parts - second check

0.00

and 11/05/31

4 0



QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

4 0 11/06/00



HandFinish

Memo

0.00

Hand Finishing

145

Fire Red(Ref.4.3.5.10) per QSI005 4.3

0.00

4x Ø 11/06/02



Powdercoat

Memo

0.00

Powder Coating

POWDER COAT: 11:20

Start Time: _____

Oven Temperature: 320

Finish Time: 11:50

N1102391

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Cust Item ID:

Required Date: 6/10/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150



QC3- Inspect Part Finish

0.00

40 BL 116-2

QC

Memo

0.00

Quality Control

160

Identify as per dwg & Stock Location: 85

0.00

85 116-62

Packaging

Memo

OK
Wb 69423

0.00

(4) _____

170



QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

116-3 HJ

MF
(1-06-03)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, May 25, 2011 1:03:46 PM

Page 1

Work Order ID: 70040



Parent Item: D3371-1



Parent Item Name: Pedal Lock Base

Start Date: 5/25/2011

Required Date: 6/10/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP A□05.01.18□New issue□KJ/JLM□IPP RevB: add powdercoat DD
10.01.18 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B2.000X02.25 0		Purchased		No		100	f	0.0000	0.625	2.631579			

6061-T6 Bar 2.00 x 2.25



2.00X3.500 Bath M112764 5/25/2011

2.632"

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	70040
Description: Pedal Lock Base	Part Number:	D3371-1
Inspection Dwg: D3371	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
60°	+/-0.5°	60°	✓		Angle meter	CNC - 03
2.25	+/-0.030	2.248	✓		Vern	GA - 01
1.650	+/-0.010	1.649	✓		"	"
1.648	+/-0.010	1.647	✓		"	"
0.700	+/-0.010	0.701	-		D-G	GA - 08
3.955	+/-0.010	3.955	✓		Vern	GA - 01
0.600	+/-0.010	0.599	✓		"	"
0.104	+/-0.010	0.107	✓		"	"
0.305	+/-0.010	0.314	-		"	"
45°	+/-0.5°	45°	✓		Angle meter	CNC - 03
0.672	+/-0.010	0.670	✓		Vern	GA - 01
Ø1.300	+/-0.010	Ø1.300	✓		"	"
1.450	+/-0.005	1.450	✓		"	"
7°	+/-0.5°	7°	✓		Angle meter	CNC - 03
2.00	+/-0.030	2.000	✓		Vern	GA - 01
1.125	+/-0.010	1.127	✓		"	"
Ø1.125	+/-0.010	Ø1.125	✓		D-R-G	ref.
R0.500	+/-0.010	R0.500	✓		Vern	GA - 01
1.000	+/-0.010	1.000	✓		Vern	GA - 01
0.375	+/-0.010	0.373	✓		"	"
Ø0.203	+0.005/-0.000	Ø0.204	✓		"	"
7.19	+/-0.030	7.185	✓		Vern	CNC - 02
4.500	+/-0.010	4.498	✓		Vern	GA - 01
0.500	+/-0.010	0.498	✓		"	"

Measured by:	B.A	Audited by:	✓	Prototype Approval:	N/A
Date:	11/05/31	Date:	11/05/31	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.04.26	New Issue	KJ/JLM	
B	05.05.25	Revised dimensions	KJ/JLM	





DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. B SHEET 2 OF 4
DATE	05.03.22	TITLE	SCALE 1:2



